

Tuesday, September 27, 2011 1:58:31 PM

Page 1

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-09-27

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Insp.
Stamp

Revision Nbr

D4306

C

100

Weld per dwg	A/R	S.S. rod	Batch:	M14649	0.00
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Large Fab

Large Fab .

Memo

0.00

1- Cut tube 50"

2- Bend tube with manuel pipe bender as per DT9567

*** Make line at 9.00" and use jig for other lines, and ensure seam in place on side of tube when bending***

3- Trim access tube material to finish size as per dwg D4306-5

4- Drill and chamfer holes as per dwg D4306-5 using DT9710

5- weld bushing as per dwg D4306

6- grind welds flush

110

QC6- Inspect dimensions to drawing

0.00

QC

Memo

0.00

Quality Control

W/O: 74289

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4306-045 PAR #: N/A Fault Category: Large PAB. welding NCR: Yes No DQA: 1 Date: 11.10.07

Resolution: ScrapDisposition: ScrapQA: N/C Closed: ckDate: 11/10/11

NCR:

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/02/08	#100	operator Drilled + welded φ. 38" holes + <u>D3755-1</u> on the main str. should have been done on the 105° end not the 90°.	<u>05242</u>	Scrap + Destroy + Replace Qty +1 <u>B M118472 m304 TS.0750.01</u> <u>D3755-1 B 72316 +2</u>	<u>Col</u> <u>11.09.08</u>	<u>8</u> <u>11/05/08</u>	<u>05242</u>	<u>11/21/08</u>
		R-L. Lug was didn't pay atten to Dwg.						

NOTE: Date & initial all entries

Work Order ID 74289

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Page 2

Item ID:	D4306-045	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Rib Assembly					
Start Date:	9/27/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	9/30/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC10- Inspect visual per QSI004- ground welds	0.00							
QC	Memo	0.00							
Quality Control									
130	Identify as per dwg & Stock Location: <u>WA</u>	0.00							
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
QC	Memo	0.00							
Quality Control									

8/10/11

PL 11-09-29

11/10/3

MF 11-09-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

Tuesday, September 27, 2011 1:58:28 PM

Page 1

Work Order ID: 74289

Parent Item: D4306-045

Parent Item Name: Rib Assembly



Start Date: 9/27/2011

Required Date: 9/30/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.01.20 new issue DD verf:EC
11.03.03 AS PER DWG REV.C DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3759-1 Bushing		Manufactured	No			100	Each	165.0000	4	4			
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Location	Loc Qty	Loc Code
WA	163	
72316	163	
WA005	2	
66489	2	

M304TS0.750W.049 Purchased No 100 f 341.4518 4.166 4.385263

304 SQ Tube .75x.75x.049W

Location	Loc Qty	Loc Code
MAT018	267.0081839	
11775	98.2133	
118472	62.8252839	
118880	105.9696	
MAT034	1.8507	
117337	1.8507	
WA	72.59294	
118184	72.59294	

Pl 11.09.28

4 8

Pl 11.09.28

4.3852

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

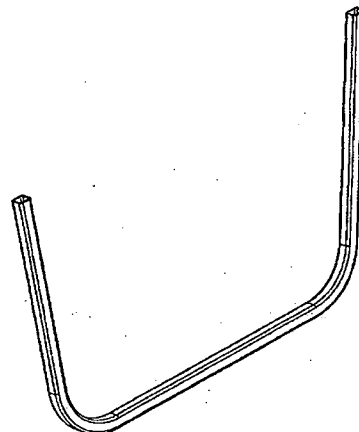
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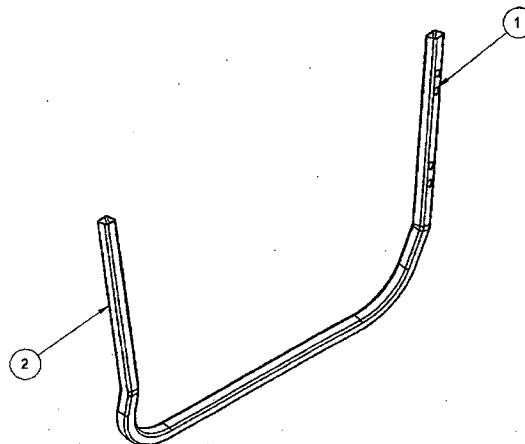
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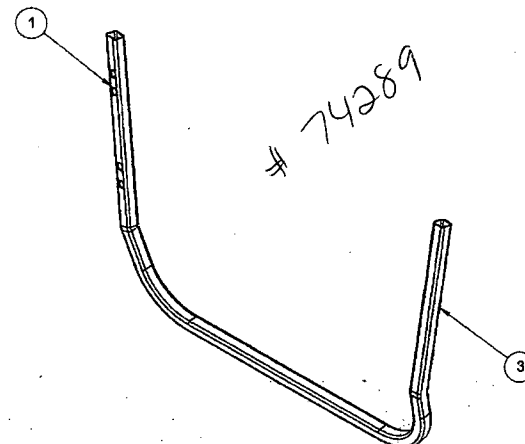
ITEM	QTY -043	QTY -044	QTY -045	P/N	DESCRIPTION
	X			D4306-043	RIB ASSY, LH
		X		D4306-044	RIB ASSY, RH
			X	D4306-045	RIB ASSY
1	4	4	4	D3759-1	BUSHING
2	1			D4306-3	RIB
3		1		D4306-4	RIB
4			1	D4306-5	RIB



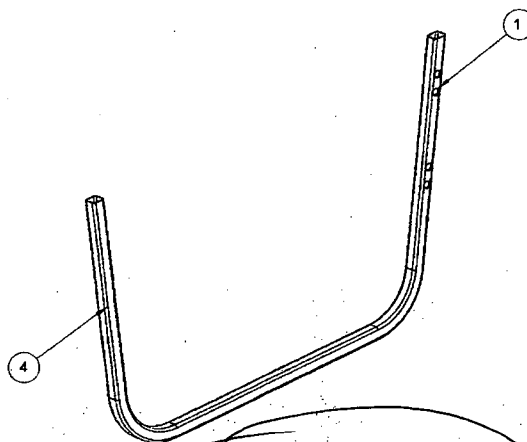
D4306-1 RIB



D4306-043 RIB ASSY, LH



D4306-044 RIB ASSY, RH



D4306-045 RIB ASSY

RELEASED
2011-03-10

C	REFERENCE LENGTH CHANGED TO 52.0" FOR D4306-3, D4306-4 RIBS (A7-A8); INCREASED LENGTH OF D4306-3, D4306-4 RIBS BY 0.85" (C7-4, C8-4, C1-5, C2-5); CHANGED CUT ANGLE FROM 19° TO 22° (B8-4, B1-5); ADDED 4.50" REF DIM ON D4306-043/044 (B6-3, B3-5)	SC	11.02.09
B	D4306-043, D4306-044, D4306-045 ADDED	SC	10.12.17
A	NEW ISSUE	CP	10.11.29
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4306 TITLE RIB DATE 11.02.09 COPYRIGHT © 2010 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR REPRODUCED TO ANY OTHER PERSON OR ENTITY WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	SC		
CHECKED			
MFG. APPR.			
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DE APPR.		REV. C	SHEET 1 OF 8
DATE	11.02.09	SCALE	NTS

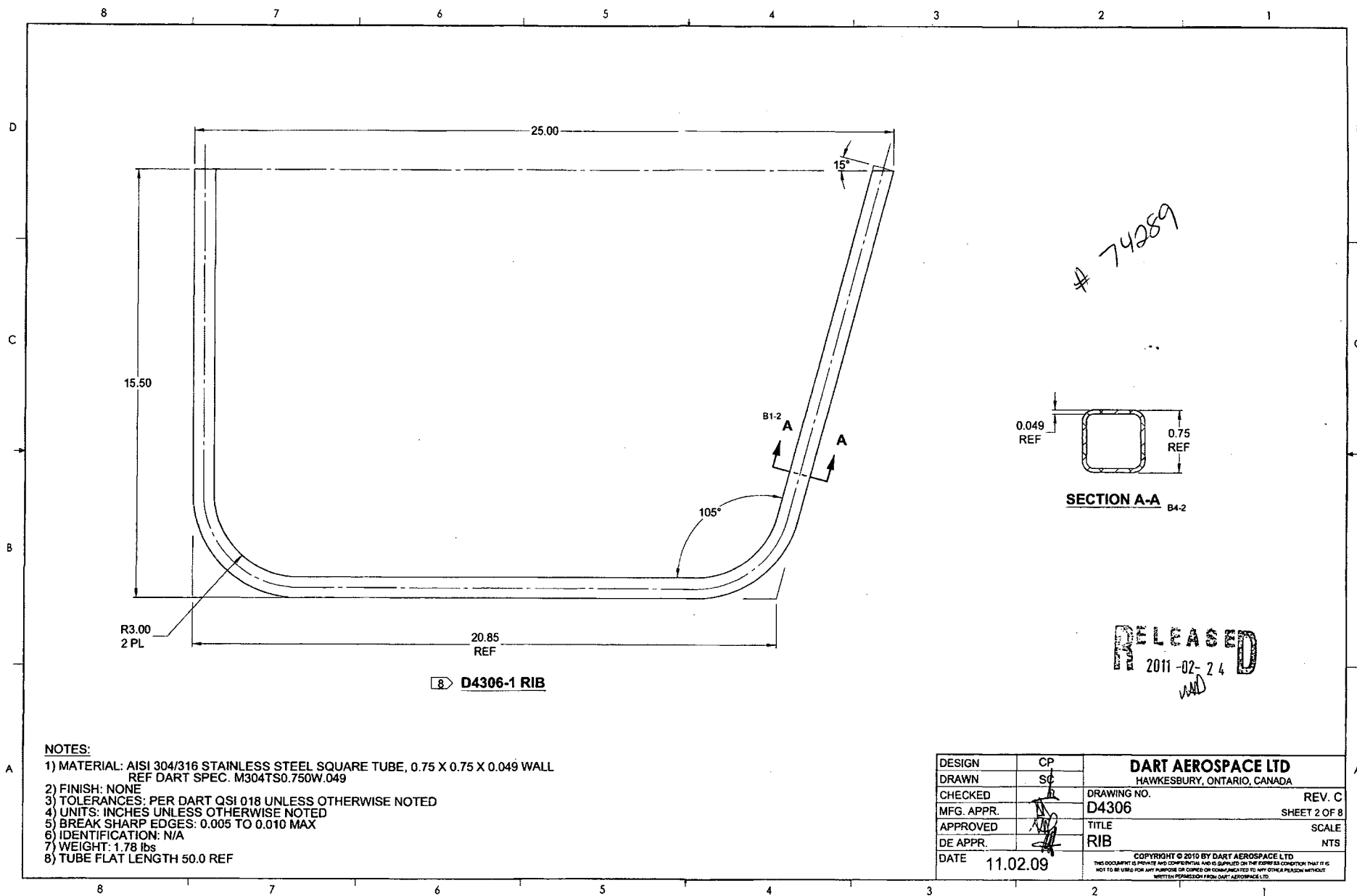
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NOTE: Date & initial all entries



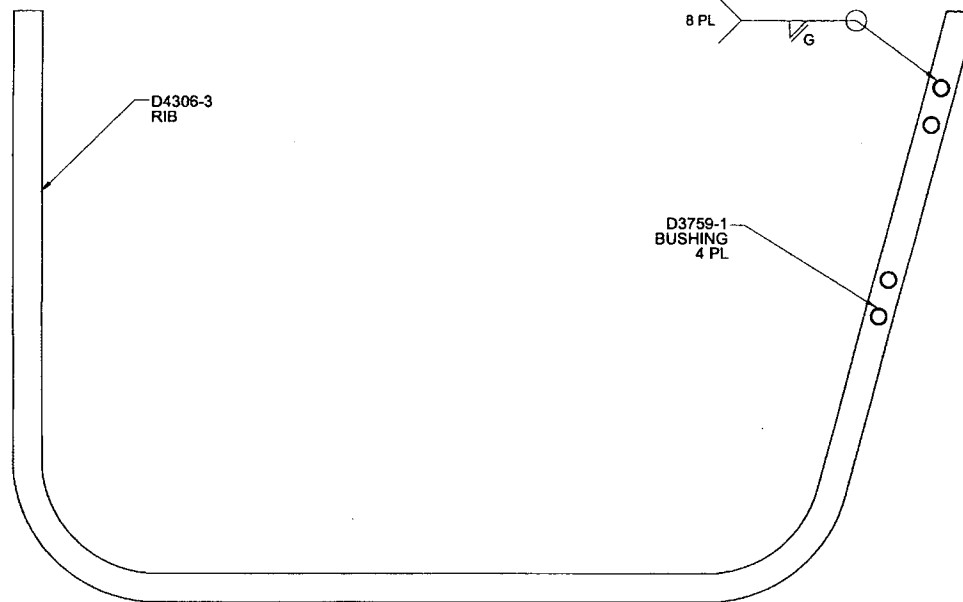
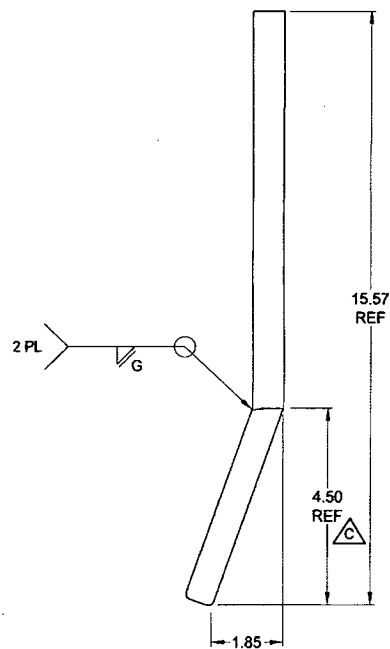
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D4306-043 RIB ASSY, LH

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.78 lbs
- 8) WELDING: PER DART QSI 004

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.		D4306	SHEET 3 OF 8
APPROVED		TITLE	SCALE
DE APPR.		RIB	NTS
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RELEASED
2011-02-24
ND

74289

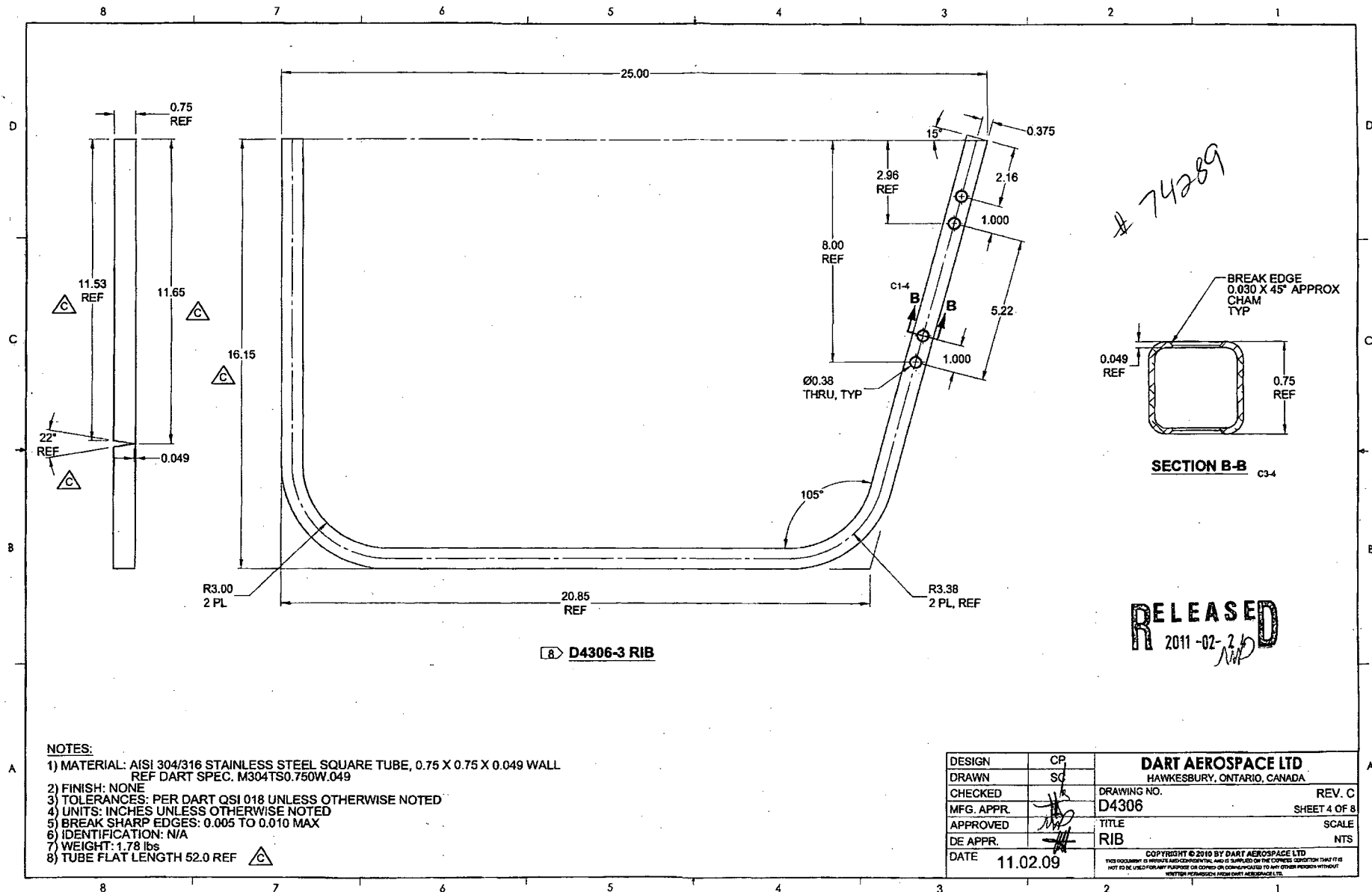
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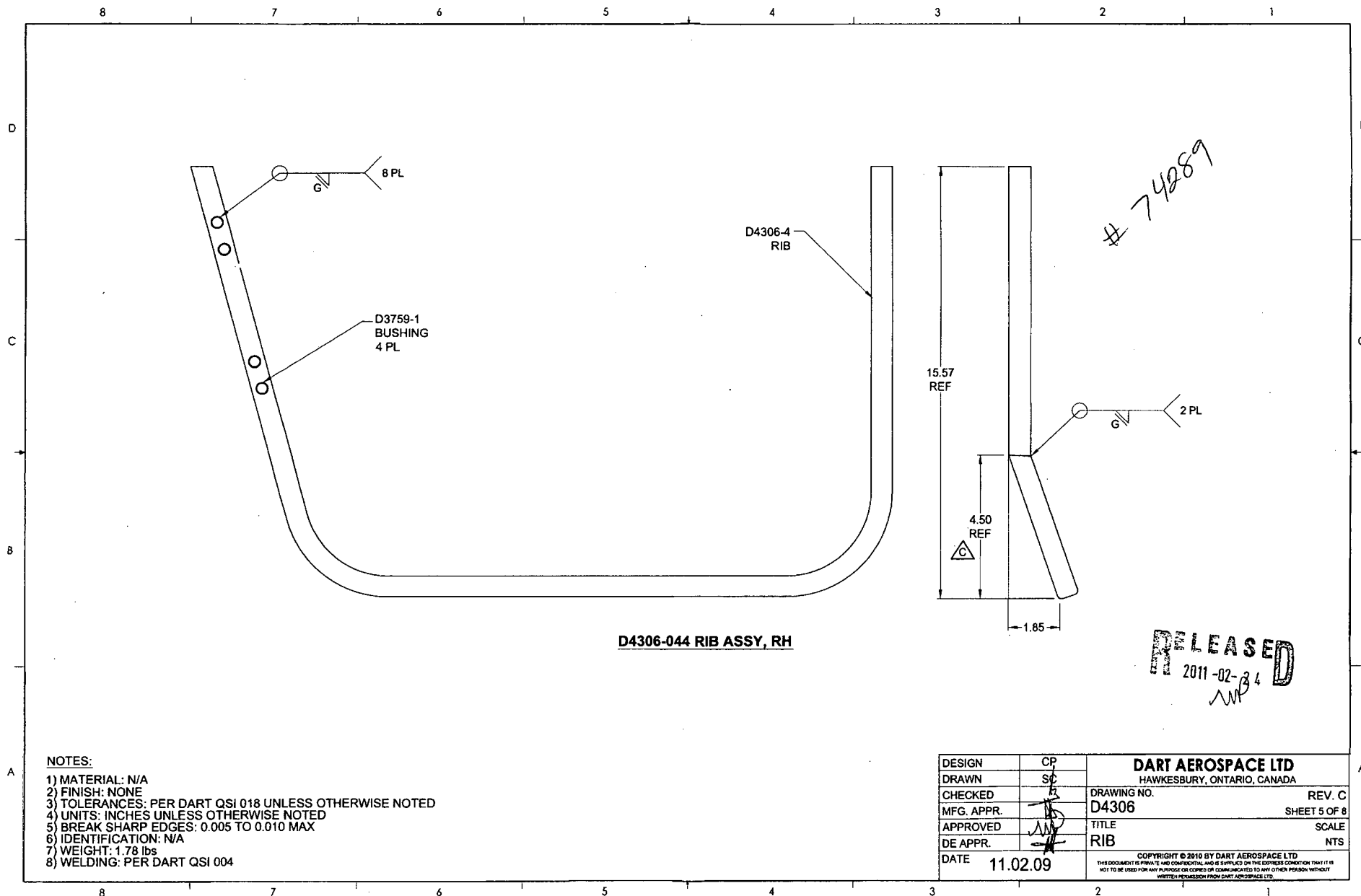
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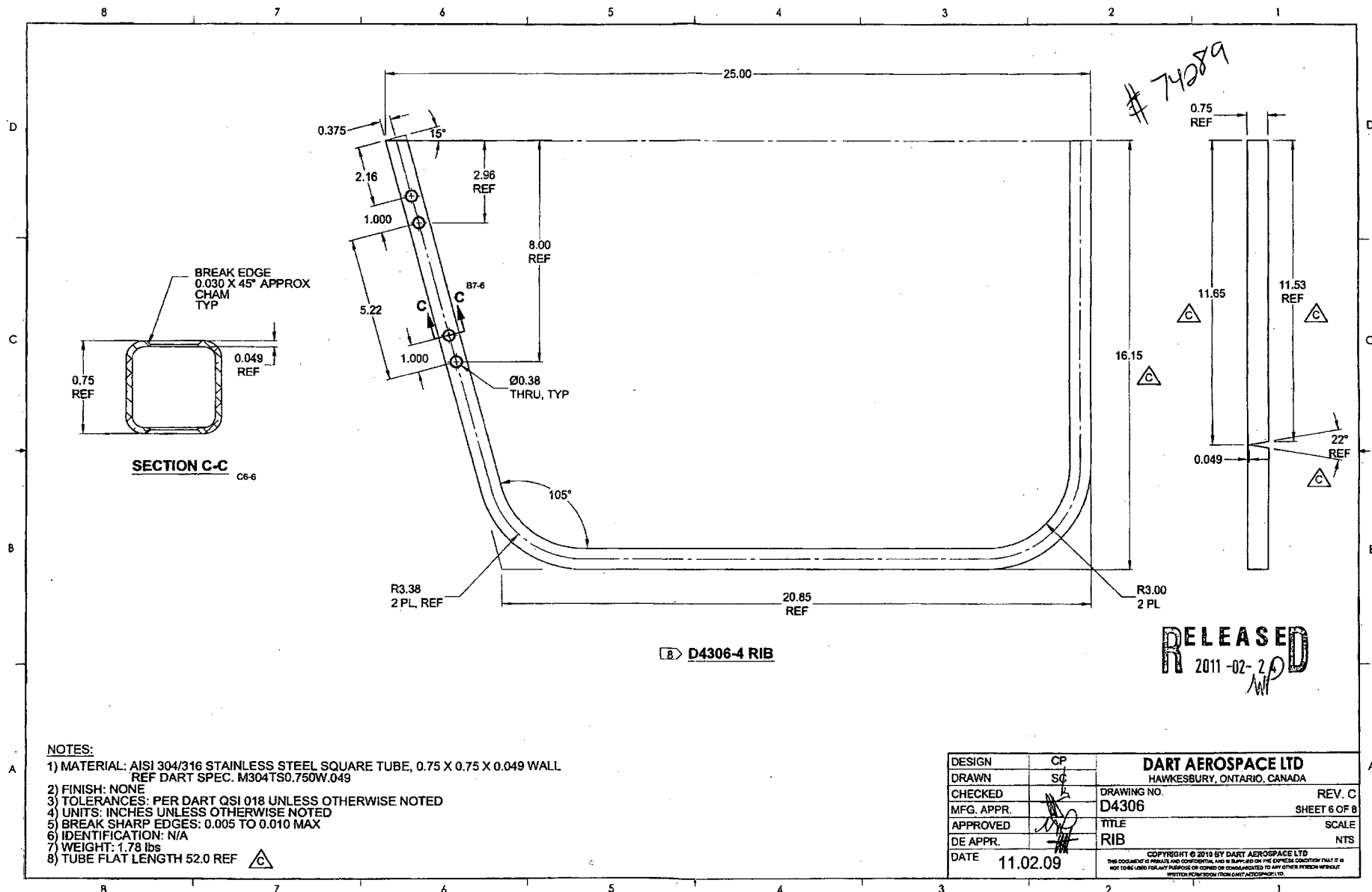
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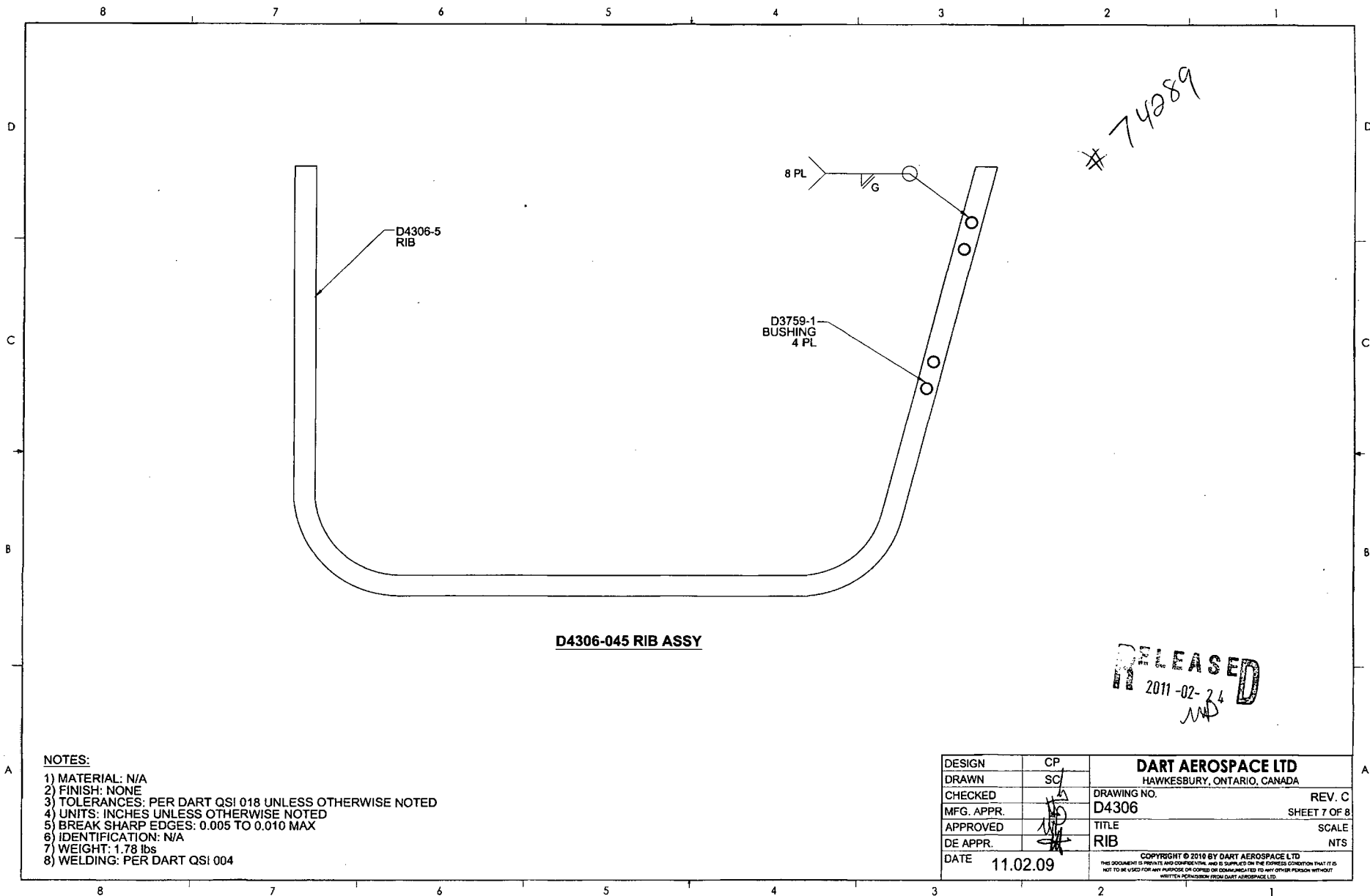
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